

Date: Thursday, 2/1/2007 2:50:07 PM
User: Kinf Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT ASSEMBLY
Job Number	: 30581		
Estimate Number	: 12695	Part Number	: D2302
P.O. Number	: N/A	Drawing Number	: D2303 REV E
This Issue	: 2/1/2007 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: E
First Issue	: N/A Type : SMALL /MED FAB	Material	: N/A
Previous Run	: N/A	Due Date	: 3/15/2007 Qty: 4 Um: Each
Written By	:		
Checked & Approved By	: <u>07.02.01</u>		
Comment	: Est Rev: A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2318	Heater Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Heater Support
Batch: B3851=2 B30601=6 J.E. 07.03.07 4

2.0	D2285	Tube Locator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Tube Locator
Batch: B3853=4 B31090=4 J.E. 07.03.07 4

3.0	D2290	Heater Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Heater Tube
Batch: B30597 J.E. 07.03.08 4

4.0	D2291	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Heater Tube 4"
Batch: B30598 J.E. 07.03.08 4

5.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Heater Tube 4"
Batch: B27216=3 B26912=1 J.E. 07.03.09 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/1/2007 2:50:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT ASSEMBLY

Job Number: 30581

Part Number: D2302

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2293

Heater Tube 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 6"

Batch: B30620

PE. 07.03.09

4

7.0

AN81816D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: B2535

PE. 07.03.13

4

8.0

MS2081916D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Batch: B2535

PE. 07.03.13

4

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2302 USING DT 2302

A/R AL ROD

Batch: M100237

PE. 07.03.13

370

4

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07.03.15 (4)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.03.15 (4)

12.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3336

RED Anodize weldment as per Dwg D2303

Ensure Certificate of Conformity is attached

C207103/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01-03-13	9	welded support plate on wrong side had to cut off and weld on good side. scrap 2 pcs 02302	<i>[Signature]</i> 07/03/13	cut of support plate and welded new support plate on proper side	07-03-13 <i>[Signature]</i> 07/03/13	<i>[Signature]</i> 07/03/13	<i>[Signature]</i> 07/03/13	

NOTE: Date & initial all entries

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Process Sheet

Customer: • CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT ASSEMBLY

Job Number: 30581

Part Number: D2302

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

2/1/07 (4)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1207-03-27 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1207-03-27 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1207-03-30

Job Completion



1207-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. E
CHECKED	APPROVED	D2302	SHEET 1 OF 2
BW	BW		
DATE	TITLE		
94.10.25	INTAKE WELDMENT ASSEMBLY		
D	JAN. 10, 1995	GENERAL REVISION	
E	96.01.26	REMOVED REV FROM PART LIST	

QTY	Part No.	Description
X	D2302	INTAKE WELDMENT ASSEMBLY
2	D2285	HEATER TUBE LOCATOR
1	D2290	1" HEATER TUBE
1	D2291-1	4" HEATER TUBE
1	D2292	4" HEATER TUBE
1	D2293	6" HEATER TUBE
1	D2318	END PLATE
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE

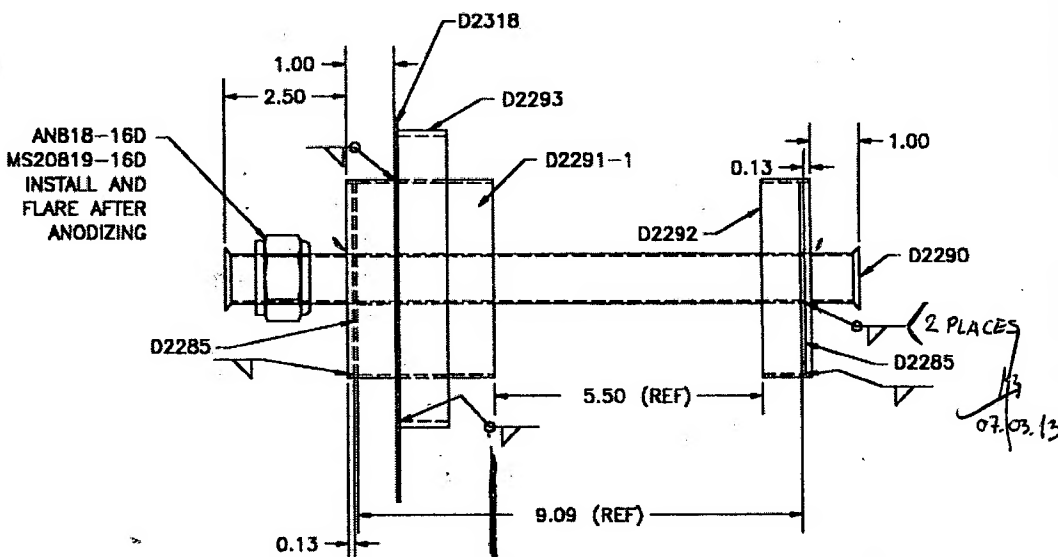
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30581

DART

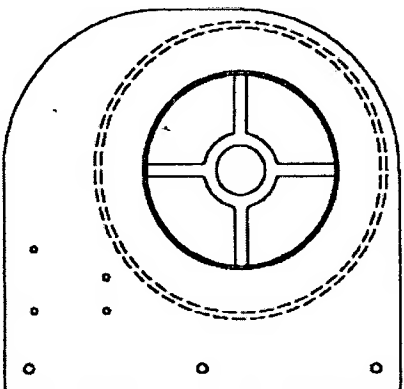


DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	<i>B.W.</i>	APPROVED	<i>B.W.</i>	DRAWING NO. D2302
DATE	94.10.25	TITLE	INTAKE WELDMENT ASSEMBLY	REV. E SHEET 2 OF 2
		SCALE		

exhaustable



FINISH: ANODIZE



D2318

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30581

11111

ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, QC H9R 4Z2
 Telephone: (514) 429-7777 Fax: (514) 429-5108
 Certifié ISO 9001-2000 / ISO 9001-2000 certified
 Certifié NADCAP / NADCAP certified

FACTURE
 INVOICE

53941

22-Mar-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
 1270 ABERDEEN STREET
 HAWKESBURY, ONTARIO
 K6A 1K7

PURCHASE ORDER/
 NO. DE COMMANDE: 00003336

CONDITIONS / TERMS:
 NET 30 JOURS / NET 30 DAYS

QTY	QTY	QTY	DESCRIPTION	UNIT PRICE	TOTAL PRICE
1	4	4	D2302	B30581	\$22.50
2	4	4	D2303	B30582	\$22.50
SUB TOTAL:					\$180.00
TPS/GST:					\$10.80
TVQ/PST:					\$0.00
TOTAL AMOUNT DUE:					\$190.80

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
 CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du
 traitement des pieces perdues ou endommagées.
 Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

